



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2891-1
Job Sheet 209232



Part No: D2891-1

Job Qty: 18 pcs

Part Name: Support 2.25



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/17/20

Job Tracking No:

Due Date: 4/30/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG D2891 REV C IPP C 08.03.19 Re-format EC verified:DD/IPP Rev:E 11.08.04 as per dwg rev.B DD
verf:EC/IPP Rev.F 19.12.02 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	HAAS 4 Axis	18 pcs	4/29/20	1.00	14.75	HAAS - 1		
						HAAS - 2		
						HAAS - 3		
						HAAS - 4		
110	QC 2	18 pcs	4/29/20	0.00	0.00	QC 2 - 1	mark 20/04/19	
						QC 2 - 12		
						QC 2 - 14		
						QC 2 - 17		
						QC 2 - 19		
						QC 2 - 2		
						QC 2 - 20		
						QC 2 - 22		
						QC 2 - 23		
						QC 2 - 25		
						QC 2 - 32		
						QC 2 - 33		
						QC 2 - 35		
						QC 2 - 39		
						QC 2 - 4		
						QC 2 - 40		
						QC 2 - 44		
						QC 2 - 45		
						QC 2 - 48		
						QC 2 - 49	mark 20/04/19	
						QC 2 - 50		
						QC 2 - 51		
						QC 2 - 52		
						QC 2 - 57		
						QC 2 - 62		
						QC 2 - 63		



DART
AEROSPACE

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1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S271651



Part: D2891-1
Job No: 209232
Serial No/Batch: S271651
Revision: C
Inspector:
Exp Date:
Instructions: Various STC's

Date: 04/19/20



Container No: S271651



Part: D2891 - 1

Job No: 209232

Serial No/Batch: S271651

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 04/19/20

				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	18 pcs	4/29/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
130	Crosstubes - 2 - B4B	18 pcs	4/30/20	0.00 0.85	Crosstubes - 1 - B4B
					Crosstubes - 2 - B4B
					Crosstubes - 3 - B4B
					Crosstubes - 4 - B4B
140	QC 3	18 pcs	4/30/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59

D.A 20-04-19

DAS

41 APR 19 2020

3-89

				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	APR 20 2020
				QC 3 - 87	
170	Packaging 3-1 - Stock - B4B	18 pcs	4/30/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
180	QC 21 - SA	18 pcs	4/30/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **100** - HAAS CNC Vertical Machine - 1-Machine as per Folio FA046
 Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - Crosstubes - Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. *5206977 - xp 8/21*
140 - QC3- Inspect Part Finish
170 - Identify as per dwg & Stock Location: *LG050* LOCATION : *LG052*
180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
DSK076	D2891-1 Turning Detail	9 pcs (.5 ea)	100-HAAS 4 Axis	S251416

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK076	9	28	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.188Inches ± 0.000	0.000 0.188		
2	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
3	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
4	2.250 Support	0.040Inches ± 0.000	0.000 0.040		
5	2.250 Support	0.010Inches ± 0.000	0.000 0.010		
6	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
7	2.250 Support	0.290Inches ± 0.000	0.000 0.290		
8	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
9	2.250 Support	0.454Inches ± 0.000	0.000 0.454		
10	2.250 Support	2.779Inches ± 0.000	0.000 2.779		
11	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
12	2.250 Support	1.002Inches ± 0.000	0.000 1.002		
13	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
14	2.250 Support	0.257Inches ± 0.000	0.000 0.257		
15	2.250 Support	1.663Inches ± 0.000	0.000 1.663		
16	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
17	2.250 Support	0.022Inches ± 0.000	0.000 0.022		

Plex 4/17/20 2:53 PM dart.lacelle.linda



DART AEROSPACE LTD		Work Order: 209232
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.247	.247	.247	.257	.247
AC	0.115	0.150		.126	.127	.126	.127	.125
AD	0.040	0.060		.048	.048	.047	.045	.048
AE	0.010	0.020		.012	.012	.012	.012	.012
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		.138	.138	.140	.138	.138
AI	0.454	0.474		.463	.463	.463	.463	.463
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.032	1.032	1.034	1.031	1.034
AM	0.053	0.073		.060	.060	.060	.060	.060
AN	0.257	0.262		.257	.257	.257	.257	.257
AO	1.663	1.683		1.677	1.673	1.675	1.675	1.675
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR	0.090	0.110		.095	.095	.096	.098	.095
AS								
AT								
Accept/Reject								

Measured by: mmc	Date: 20/04/18
Audited by: BA	Date: 20-04-19
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 209232
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	#9	#10
HAAS Section								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.247	.247	.247	.250	.250
AC	0.115	0.150		.124	.124	.124	.124	.125
AD	0.040	0.060		.047	.047	.047	.047	.047
AE	0.010	0.020		.012	.012	.012	.012	.012
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		.138	.138	.138	.138	.137
AI	0.454	0.474		.463	.463	.463	.463	.463
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.032	1.032	1.032	1.035	1.037
AM	0.053	0.073		.060	.060	.060	.060	.060
AN	0.257	0.262		.257	.257	.257	.257	.257
AO	1.663	1.683		1.675	1.677	1.677	1.675	1.675
AP	0.053	0.073		.063	.063	.063	.062	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR	0.090	0.110		.095	.095	.095	.095	.095
AS								
AT								
Accept/Reject								

Measured by: mal	Date: 20/01/18
Audited by: Ra	Date: 20-04-19
Preliminary Approval:	Date:

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C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 209232
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.250	.250	.244	.244	.247
AC	0.115	0.150		.125	.125	.124	.124	.125
AD	0.040	0.060		.047	.047	.050	.050	.050
AE	0.010	0.020		.012	.012	.012	.012	.012
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		.139	.139	.139	.139	.139
AI	0.454	0.474		.464	.464	.463	.463	.464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.032	1.033	1.034	1.033	1.037
AM	0.053	0.073		.060	.060	.060	.060	.060
AN	0.257	0.262		.257	.257	.257	.257	.257
AO	1.663	1.683		1.674	1.674	1.678	1.678	1.675
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR	0.090	0.110		.095	.096	.095	.095	.095
AS								
AT								
Accept/Reject								

Measured by: [Signature]	Date: 20/04/19
Audited by: B.A.	Date: 20-04-19
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	[Signature]

DART AEROSPACE LTD		Work Order: 209232
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	4	5
HAAS Section								
AA	0.188	0.193		.189	.189	.189		
AB	0.240	0.260		.247	.248	.248		
AC	0.115	0.150		.128	.129	.129		
AD	0.040	0.060		.050	.047	.047		
AE	0.010	0.020		.012	.012	.012		
AF	0.240	0.260		.250	.250	.250		
AG	0.290	0.310		.300	.300	.300		
AH	0.115	0.150		.138	.138	.138		
AI	0.454	0.474		.464	.460	.460		
AJ	2.779	2.789		2.784	2.784	2.784		
AK	0.240	0.260		.250	.250	.250		
AL	1.002	1.042		1.032	1.038	1.037		
AM	0.053	0.073		.060	.060	.060		
AN	0.257	0.262		.257	.257	.257		
AO	1.663	1.683		1.675	1.673	1.673		
AP	0.053	0.073		.063	.063	.063		
AQ	0.022	0.042		.032	.032	.032		
AR	0.090	.010		.095	.095	.095		
AS								
AT								
Accept/Reject								

Measured by: mm	Date: 20/04/19
Audited by: D.A	Date: 20-04-19
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
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